Wednesday, 2/15/2006 3:46:36 PM Kim Johnston User Prou : CU-DAR001 Dart Helicopters Services **Drawing Name** : BUSHING Customer Job Number : 25840 : 10503 **Estimate Number** : D2745 : NIA Part Number P.O. Number : D2745 REV B **Drawing Number** : 2/15/2006 S.O. No. : NIA This Issue : N/A : NC **Project Number** Prsht Rev. : NIA : MACHINED PARTS **Drawing Revision** First Issue Type : NIA : 24879 Material Previous Run 150 Um: **Due Date** : 3/3/2006 Qty: Each Written By Checked & Approved By Update to turn in house NG Comment : Est C 02.03 **Additional Product** Job Number: Seq. #: **Machine Or Operation:** Description: M303R0750 303 Round Bar .75" 1.0 Total: 15.1043 f(s) Comment: Qty.: 0.1007 f(s)/Unit 303 ROUND .75" MS 06/03/01 Batch: MIDOIST Machine per Folio FA201 Material: AISI 303 SS 2.0 HARDINGE HARDINGE CNC LATHE SMALL Comment: HARDINGE CNC LATHE SMALL 1-Turn Blank as per Dwg D2515 MS 06/03/01 2-Deburr 150 INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 PARTS AS THEY COME OFF MACHINE 150 Comment: INSPEC SECOND CHECK QC8 4.0 50 Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 5.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & deburr any sharp edges as per dwg MS 06/03/04

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANGES					
DATE STEP		PR	OCEDURE CHAI	NGE	Ву			Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:		
Part No		PAR #:	Fault Cate	gory: f	NCR: Yes	No DQ	A: <u> </u>	Date:△	6/63/67
					QA: N	/C Close	d:	Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMAN	CE (NCR	.)			
		Description of NC	Corrective Action Sec			Verific	Verification	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C			
							-		

NOTE: Date & initial all entries

Date: User:

Wednesday, 2/15/2006 3:46:36 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 25840

Part Number: D2745

Job Number:



Seq. #:

Machine Or Operation:

Description:

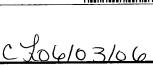
6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: FP-15



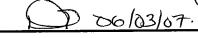


7.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21



Job Completion



Le 0603-07

Dail At	Tospace	: Ltu							
W/O:			WC	ORK ORDER CHANG	ES				
DATE STE		PR	ROCEDURE CHANGE By			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
					QA: N	I/C Close	d:	Date:	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	₹)			
5475		Description of NC	Corrective Action		Section B		cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	Section C	Chief Eng	QC Inspector
l						1			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25840
Description: Bushing	Part Number:	D2745
Inspection Dwg: D2745 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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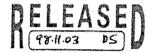
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.010	.062	~			
0.400	+/-0.010	.399	/			
0.060	+/-0.010	.062	/			
1.020	+/-0.010	1,022				
0.030 x 20°	+/-0.010	.03	~			
Ø0.472	+/-0.010	.473				
Ø0.375	+/-0.010	.376	-			
Ø0.560	+/-0.010	.561				
Ø0.750	+/-0.010	.747				
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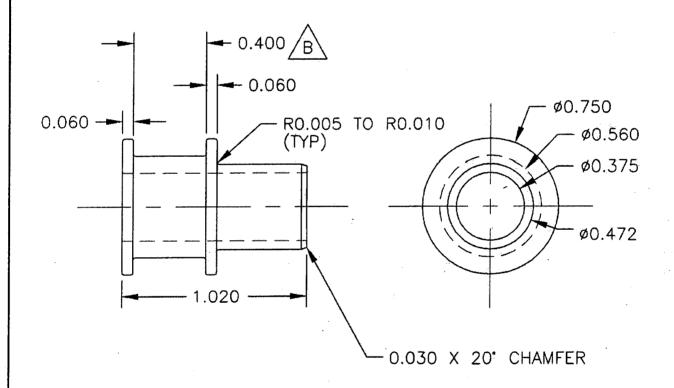
Measured by: N	1 8	Audited by:	5	Prototype Approval:	N/A
Date: 💢	603101	Date:	06/63/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.04.20	New Issue	KJ/RF	



DESIGN	DRAWN BY	DART AEROSPACE FAIRCHILD INTERNATIONAL A	
CHECKED	APPROVED	DRAWING NO.	REV. B
M	1 \$ 6	D2745	SHEET 1 OF 1
DATE		TITLE	SCALE
98.10.23		BUSHING	2:1
A	98.04.16	NEW ISSUE	
В	98.10.23	DIM 0.400 WAS 0.380	,





MATERIAL: AISI 303 STAINLESS STEEL

NOTES: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED RADIUS ALL INSIDE FORES 0.005 TO 0.010

BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020 UNCONTROLLED COPY ALL DIMENSIONS ARE IN INCHES

ALL DIMENSIONS ARE IN INCHES

SUBJECT TO AMENDMENT WITHOUT NOTICE